

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006504**Date Inspected:** 02-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Lei and Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as Tower shear plate WD1-A467-23M and WD1-A467-28M. The weld designations reviewed are as follows:

Bay 10

1. WD1-A467-23M-7, 8, 13~22, 25~96

2. WD1-A467-28M-7, 8, 13~22, 25~96

Bay 11

SMAW welding of weld joint 47A located on PCMK WSD1-FCSA3-12B/C.

Welder is identified as Mr. Cui Chunlei (205642). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-P5.

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SMAW welding of weld joint 47B located on PCMK WSD1-FCSA3-12B/C.

Welder is identified as Mr. Bai Guofeng (203272). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-P5.

SMAW welding of weld joint 27B located on ND1-A468-43M-1.

Welder is identified as Mr. Cui Guozhong (040656). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

FCAW welding of weld joint 55 and 56 located on ESD1-TL7K/L.

Welder is identified as Mr. Fan Chenfu (067501). ZPMC QC is identified as Mr. Li Lei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P6-F.

FCAW welding of weld joint 57 and 58 located on ESD1-TL7J/L.

Welder is identified as Mr. Liu Feng (069095). ZPMC QC is identified as Mr. Li Lei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P6-F.

Bay 10

SAW welding of weld joint 50A located on NSD1-A112B/H.

Welder is identified as Mr. Chen Wongxia (040460). ZPMC QC is identified as Mr. Lu Yang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-S-2.

Bay 2

FCAW welding of weld joint 003 located on SEG1E.

Welder is identified as Mr. Ren Linsheng (207465). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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